

Work Order ID 52307

Page 1

Tuesday, September 22, 2009 2:33:14 PM

Item ID: D2666-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Fwd Aft In 206



Start Date: 9/23/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: *RL*

Date: 09-09-22 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D2666	Rev D	

100 0.00

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo 0.00

8 0

HAAS CNC vertical machine #1

Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet*JL
~ ~ ~
09/10/15*110 0.00

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo 0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

*~ ~ ~
09/10/15**8 0*120 0.00

QC2- Inspect parts off machine FAI/FAIB

QC

Memo 0.00

Quality Control

*JL
~ ~ ~
09/10/15**8 0*

Work Order ID 52307

Page 2

Tuesday, September 22, 2009 2:33:14 PM

Item ID: D2666-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Fwd Aft In 206

Start Date: 9/23/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description**Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

and 09/10/16

8 0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/10/16

X8



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BL 09-10-16

8



Powdercoat

Memo

M112260

0.00

Powder Coating

START TIME:

10:30

OVEN TEMPERATURE:

320°

FINISH TIME:

11:00

Work Order ID 52307

Page 3

Tuesday, September 22, 2009 2:33:14 PM

Item ID: D2666-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Fwd Aft In 206

Start Date: 9/23/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

MD 09/10/19

X8



QC

Memo

0.00

Quality Control

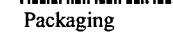
170

Identify as per dwg & Stock Location: 406

0.00

9/10/19

80 SP



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

09/10/19 JJ

QC

Memo

0.00

Quality Control

MF 09-10-19

Picklist Print

Page 1

Tuesday, September 22, 2009 2:33:14 PM

Work Order ID: 52307



Parent Item: D2666-1RevD



Parent Item Name: Saddle, LH Fwd Aft In 206

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-001RevB 		Manufactured	No			100	Each	0.0000	8.0000 			

Saddle Billet

B 46409 X 8

32

DART AEROSPACE LTD				Work Order:	52307
Description: 206 Saddle, Inboard, Left side				Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.130	.123	.123	.127		
B	0.100	0.140		.126	.126	.125	.125		
C	2.470	2.510		2.490	2.490	2.490	2.493		
D	0.100	0.180		.125	.125	.125	.126		
E	0.210	0.230		.220	.220	.219	.219		
F	1.313	1.343		1.324	1.324	1.324	1.321		
G	0.240	0.260		.251	.250	.251	.249		
H	0.615	0.685		.665	.665	.665	.660		
I	1.125	1.145		1.133	1.135	1.134	1.135		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.236	.236	.236	.237		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.110	.111	.110	.110		
N	1.565	1.585		1.573	1.575	1.574	1.579		
O	5.990	6.010		6.000	6.002	6.001	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.504		
R	0.490	0.510		.500	.497	.494	.498		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.320		
W	0.540	0.560		.549	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.256	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL	Audited by:	AM
Date:	09/10/14	Date:	09/10/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order:	52307
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.100	0.140		.125	.125	.125	.127		
B	0.100	0.140		.125	.124	.123	.124		
C	2.470	2.510		2.492	2.490	2.490	2.491		
D	0.100	0.180		.137	.138	.140	.136		
E	0.210	0.230		.220	.219	.217	.220		
F	1.313	1.343		1.321	1.326	1.325	1.326		
G	0.240	0.260		.250	.250	.250	.250		
H	0.615	0.685		.659	.663	.667	.658		
I	1.125	1.145		1.136	1.138	1.136	1.136		
J	0.990	1.010		.999	1.000	1.000	.999		
K	0.235	0.240		.237	.236	.235	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.110	.110	.110	.110		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.001	6.000	6.001	6.000		
P	1.245	1.255		1.247	1.248	1.248	1.248		
Q	2.495	2.505		2.500	2.503	2.500	2.500		
R	0.490	0.510		.501	.501	.498	.500		
S	0.313	0.318		.315	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.494	2.500		
U	1.357	1.367		1.360	1.362	1.360	1.360		
V	0.315	0.322		.320	.317	.320	.320		
W	0.540	0.560		.549	.543	.544	.545		
X	1.674	1.684		1.678	1.679	1.682	1.681		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<u>JK</u>	Audited by:	<u>JK</u>
Date:	09/10/16	Date:	09/10/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM <u>JK</u>	<u>JK</u>

SHOP COPY

RETURN TO

卷之三

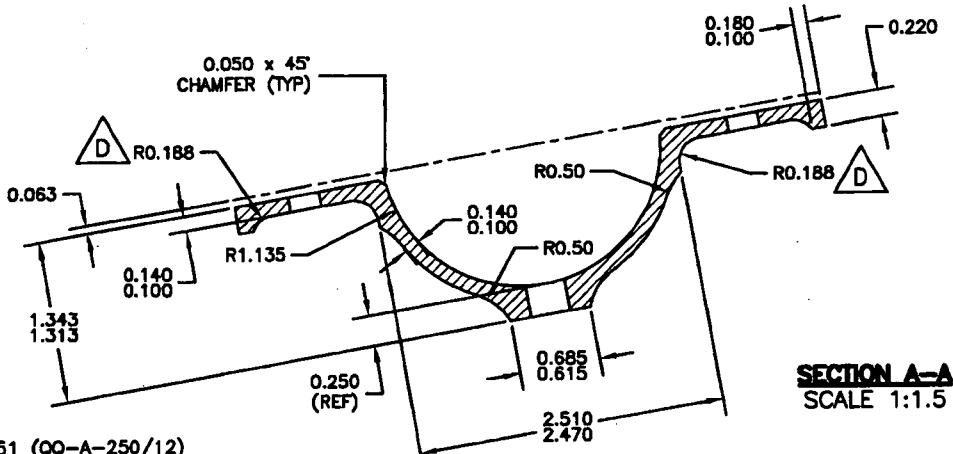
UNIVERSITY OF TORONTO LIBRARIES

**WITHOUT NOTICE
WORK ORDER**

RELEASED

07.02.12 8

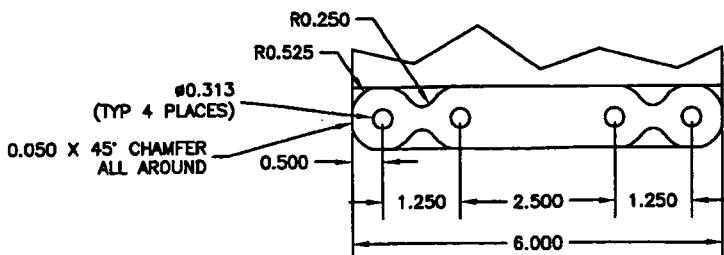
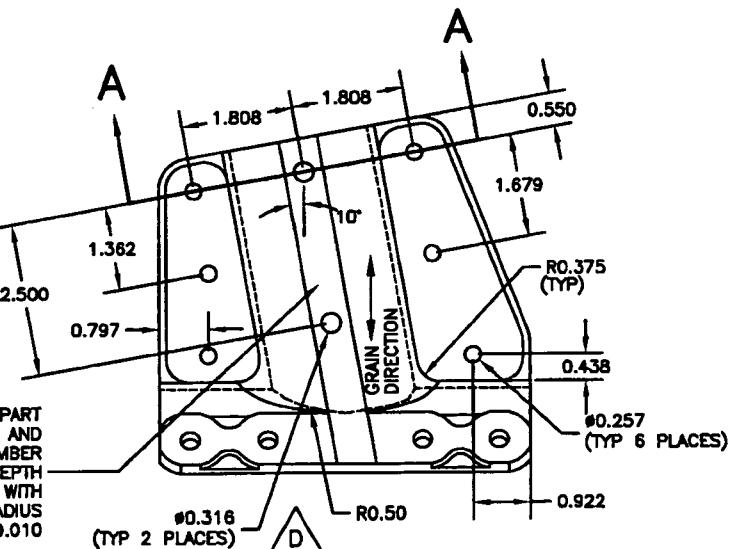
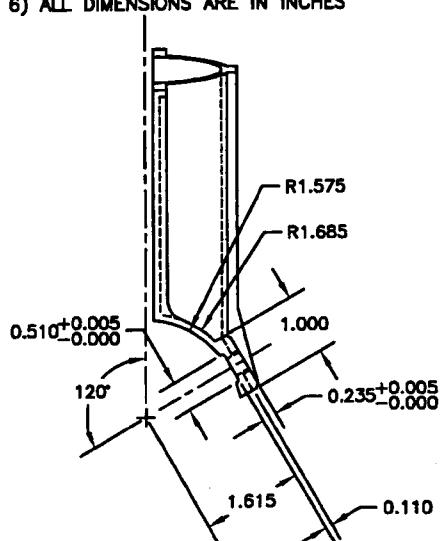
DESIGN <i>A</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	



SECTION A-A

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
 - 6) ALL DIMENSIONS ARE IN INCHES



D2866-1 SADDLE FWD INSIDE HIGH

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.